

Work Order ID 74889

74889

Page 1

October 13, 2011 11:20:23 AM

Item ID: D3806-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 10/13/11 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/15/11 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00
100 FK 11/12/16 20 9
 Cold Saw
 Hyd Mech

Memo
 Cut blanks at 44.00"
 ***FOR CLAMPING PURPOSE WHEN WELDING .500" WAS ADDED ON
 LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING***

110 0.00
110 20 0 11/12/18
 HAAS 1

HAAS CNC vertical machine #1
 Memo
 1-Mill as per folio FB070 & dwg
 FOLIO REV: AA
 DWG REV: 8
 2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo ***FOR CLAMPING PURPOSE WHEN WELDING .500" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING***	0.00 0.00				20	0		11/12/18
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		29 11.12.19		20			
133 *133* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: _____ Memo 1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#: _____ ***CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT***	0.00 0.00							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC10- Inspect visual per QS1004- ground welds Memo	0.00 0.00							
137 *137* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>w/a</i> Memo	0.00 0.00							

will be done on assembly w/o.

12 11-12-21 (20)

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Work Order ID 74889***74889***

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 10/13/11 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

11/12/22 [Signature]
MF
11-12-21

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NOTE: Date & initial all entries

Picklist Print

October 13, 2011 11:20:27 AM

Page 1

Work Order ID: 74889

74889

Parent Item: D3806-5

D3806-5

Parent Item Name: Bar

Start Date: 10/13/11

Required Date: 11/15/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.500X2.500

Purchased

No

100

f

13.0870

3.666

77.17895

M304B0 500X2 500

**

77.2

SL 11/12/18

304 BAR .500 x 2.50

. 500 X. 250

Location

Loc Qty

Loc Code

MAT050

13.087

112764

8.312

116135

0.375

117685

4.4

119159

77.2 St.

not issued yet

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

D3806-1 BAR

D3806-5 BAR

D3806-3 BAR

D3806-7 BAR

RELEASED
2011-10-03
MD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~74889~~ *MLJ*
74889/11/10/12

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY. 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-106		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3806 TITLE BAR SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		
DRAWN	<i>g</i>			
CHECKED	<i>g</i>			
MFG. APPR.	<i>g</i>			
APPROVED	<i>g</i>			
DE APPR.	<i>g</i>	REV. B SHEET 1 OF 3 DATE 11.09.29		

8 7 6 5 4 3 2 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

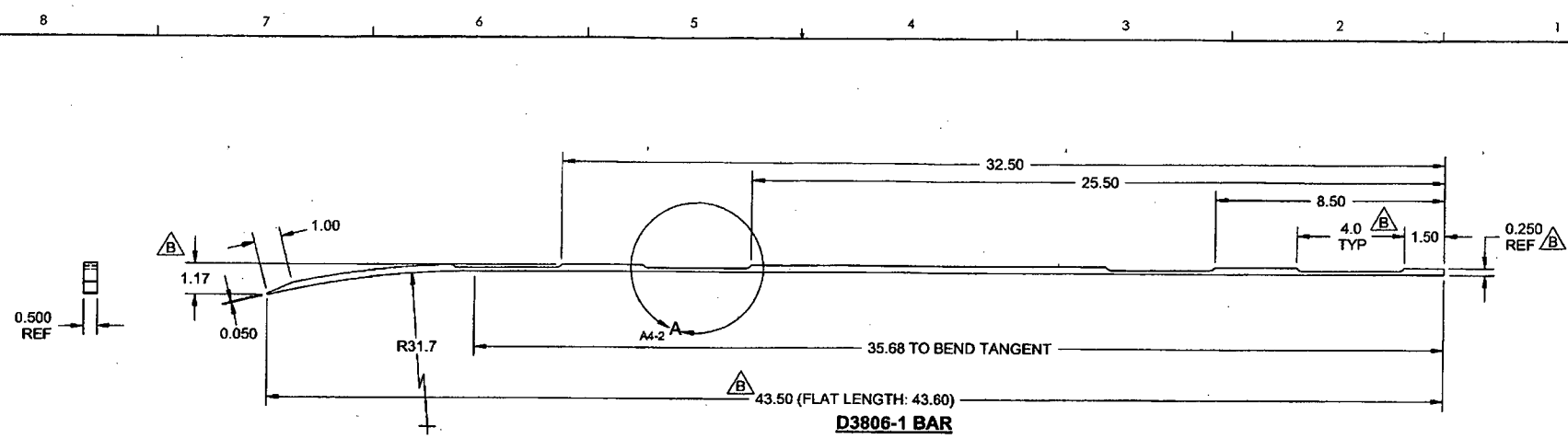
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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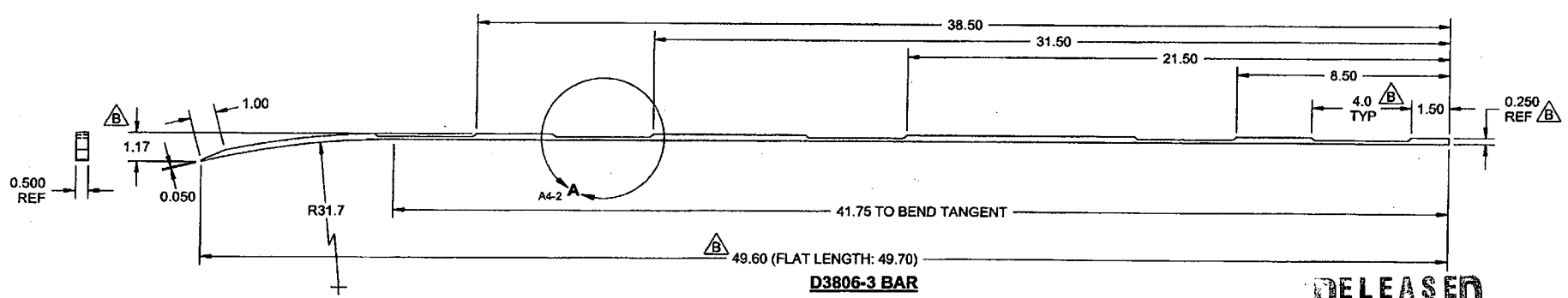
NOTE: Date & initial all entries

74889

7/18/84



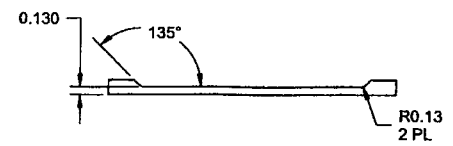
D3806-1 BAR



D3806-3 BAR

RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DETAIL A
TYP, SCALE 2X

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3806	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAR	NTS
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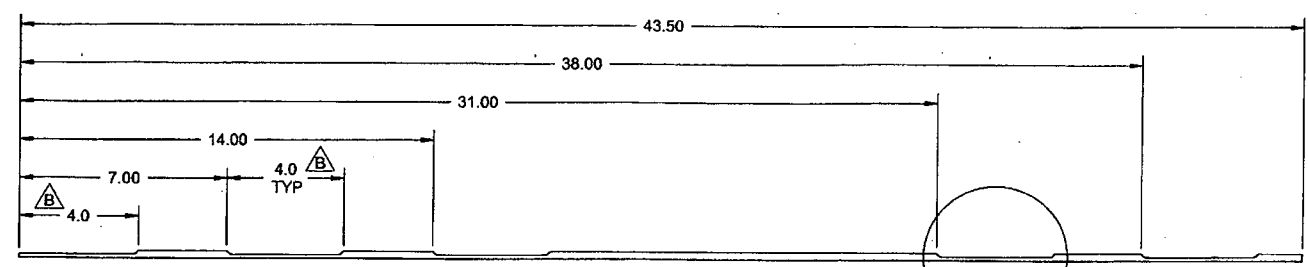
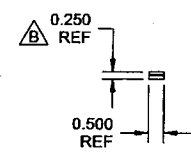
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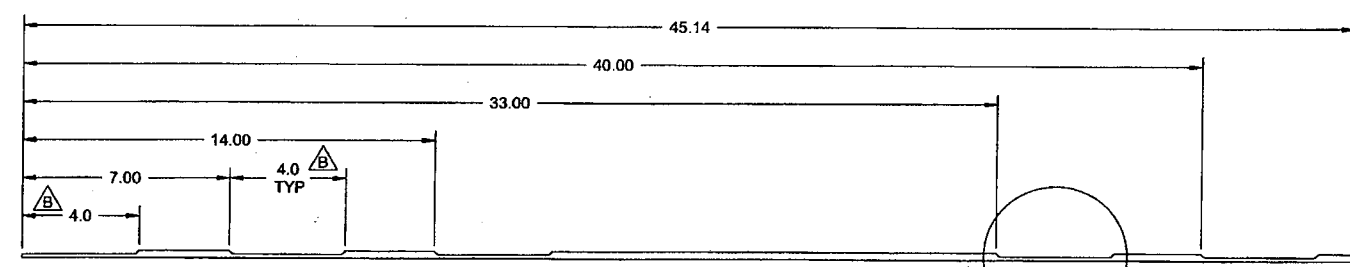
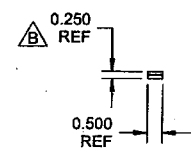
74889

74884

8 7 6 5 4 3 2 1



D3806-5 BAR



D3806-7 BAR

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

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